

Work Order ID 80509

February-21-12 5:19:20 PM

80509

Page 1

Item ID: D350-588-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop

NS2

Start Date: 21/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/02/21 Tooling:

Date:

Run

Start

NR1

QC:

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100 ***100***

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

MLJ 12/04/12

110

110

Packaging

Packaging

Pick Kit

0.00

12/3/12 MLJ 100

Memo

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

MLJ 100100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80509***80509***

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Item ID: D350-588-011

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Stop

NS2

Start Date: 21/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

0.00

(10x)

12/4/12

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-588-011

Location: 120PPP Rev: Q

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

MLJ 12/04/12

Memo

0.00

12/04/12

W/O:		WORK ORDER CHANGES						
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Work Order ID: 80509

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

80509

D350-588-011

Start Date: 21/02/2012

Start Qty: 10.00

Required Date: 20/03/2012

Required Qty: 10.00

Comments: IPP Rev:M04.08.31 Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No			120	Each	100.0000	2	20	✓		Z

AN526C1032R7

S 40 Screw

Location	Loc Qty	Loc Code
ST348	100	
116304	8	
119449	92	

AN526C832R8

Purchased No

120 Each 147.0000

**

AN526C832R8

S 40 Screw

Location	Loc Qty	Loc Code
ST346	100	
120717	100	
ST347	47	
118926	5	
119798	42	

AN526C832R9

Purchased No

120 Each 220.0000

**

AN526C832R9

S 40 Screw

Location	Loc Qty	Loc Code
ST346	200	
120181	200	
ST347	20	
118983	20	

AN960JD10

NAS1149D0363J Purchased

No

120 Each 0.0000

**

AN960.JD10

Washer

m 120.980 40 35
12/4/13

m 120.614

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 80509

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

80509

D350-588-011

Start Date: 21/02/2012

Start Qty: 10.00

Required Date: 20/03/2012

Required Qty: 10.00

AN960JD8	NAS1149DN832	Purchased	No	120	Each	0.0000	24	240
----------	--------------	-----------	----	-----	------	--------	----	-----

**

M120432

SAD *AN960.JD8*

Washer

D2143		Manufactured	No	120	Each	26.0000	1	10
-------	--	--------------	----	-----	------	---------	---	----

**

SL

SAD *D2143*

Hinge Bracket

Location	Loc Qty	Loc Code
ST	Parte 10 76100	-12 26
ST198	38	

D2144		Manufactured	No	120	Each	0.0000	1	10
-------	--	--------------	----	-----	------	--------	---	----

**

B73553

SAD *D2144*

Hinge Bracket

D2150		Manufactured	No	120	Each	22.0000	2	
-------	--	--------------	----	-----	------	---------	---	--

**

SL

SAD *D2150*

Packer Doubler, Hinge

Location	Loc Qty	Loc Code
ST005	22 22	
	76953	

D2151		Manufactured	No	120	Each	26.0000	2	20
-------	--	--------------	----	-----	------	---------	---	----

**

SL

SAD *D2151*

Packer Doubler, Hinge

Location	Loc Qty	Loc Code
ST005	26	
	76093	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 80509

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

80509
D350-588-011

Start Date: 21/02/2012

Start Qty: 10.00

Required Date: 20/03/2012

Required Qty: 10.00

D2153

Manufactured No

120 Each 70.0000

1 10

**

S *D2153*
Door Prop
AD

D2154

Manufactured No

78369 120 Each 19.0000

10 10

**

S *D2154*
Stud Bracket

D2237

Manufactured No

77024 120 Each 32.0000

10 20

**

S *D2237*
Striker Plate
AD

D2461

Manufactured No

66139 120 f 290.9887

10 7631579

**

S *D2461*
Neoprene "D" Seal
AD

S *D2461*
Neoprene "D" Seal
AD
cut 1 X 87.00"

Location Loc Qty Loc Code

ST006 32

11

66139 1

11

77046 29

11

77872 2

11

120 f 290.9887

12/4/13

7.25

Location Loc Qty Loc Code

ST402 290.9887

11

39782 6.5

11

55054 4

11

63880 7.6237

11

73644 272.865

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2463

Manufactured No

120 f 529.3369 7.25 6.31579

**

S *D2463*

Seal

AU

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST404	529.3369	
72232	36.88	
79478	492.4569	

cut 1 X 87.00"

D2583

Manufactured No

120 Each 27.0000 2 20

**

S *D2583*

AU Hatch Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST011	27	
78402	27	

D2585

Manufactured No

120 Each 78.0000 2 20

**

S *D2585*

AU Mounting Channel

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST011	78	
73297	2	
77696	17	
78805	59	

D2586

Manufactured No

120 Each 69.0000 2 20

**

S *D2586*

AU Door Latch

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST203A	69	
77697	69	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 80509

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

D2587

D2587

Door Slug, 350 Hinge

SD

AD

Manufactured

No

120

Each

53.0000

1

10

**

sf

C

D2589

D2589

Keys, Key Chain, 350 Hinge

SD

AD

Manufactured

No

120

Each

22.0000

1

10

**

sf

C

D2690-17

D2690-17

Cable

SD

AD

Manufactured

No

120

Each

16.0000

1

10

**

sf

C

D2857-1

D2857-1

Hinge Bracket

SD

AD

Manufactured

No

120

Each

23.0000

1

10

**

12/4/12 sf

C

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 80509

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

D2857-2

Manufactured

No

120

Each

18.0000

1

10

**

D2857-2

S
WD

D2858-1

Manufactured

No

120

Each

29.0000

1

10

**

D2858-1

S
WD

D2858-2

Manufactured

No

120

Each

24.0000

1

10

**

D2858-2

S
WD

FG-778150-550-ROL

Purchased

No

120

sf

3,246.651

1

10

**

FG-778150-550-ROL

S
WD

1-cut 1 square ft of glass cloth

February-21-12 5:19:25 PM

80509

D350-588-011

Start Date: 21/02/2012

Start Qty: 10.00

Required Date: 20/03/2012

Required Qty: 10.00

Location Loc Qty Loc Code

ST019 18

75252

18

10

ST019 120

Each

29.0000

1

10

**

Location Loc Qty Loc Code

ST019 29

75250

8

8

ST019 21

Each

24.0000

1

10

**

Location Loc Qty Loc Code

ST019 24

75251

4

4

ST019 20

sf

3,246.651

1

10

**

Location Loc Qty Loc Code

CA 3246.651

104845

3

3

108932 18

18

18

111166 392

392

392

113905 563

563

563

117602 680.651

680.651

680.651

119099 1590

1590

1590

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 80509

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

MS20426AD3-4

Purchased

No

120

Each

4,006.000

12

120

**

MS20426AD3-4

RIVET

S

HD

MS20470AD4-5

Purchased

No

120

Each

3,015.000

18

180

**

MS20470AD4-5

Rivet, Universal Head

MS21042L08

Purchased

No

120

Each

323.0000

18

180

**

MS21042L08

Nut

MS21042L3

Purchased

No

120

Each

4,257.000

4

40

**

MS21042L3

Nut

February-21-12 5:19:25 PM

80509
D350-588-011

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

Location	Loc Qty	Loc Code
----------	---------	----------

ST316	4006	
104374	1024	
110398	2982	

120

Location	Loc Qty	Loc Code
----------	---------	----------

ST319	3015	
118405	1362	
120142	1653	

180

Location	Loc Qty	Loc Code
----------	---------	----------

ST300	323	
120142	123	
120648	200	

19
17

Location	Loc Qty	Loc Code
----------	---------	----------

ST300	4257	
117441	16	
117885	32	
118451	5	
118927	3	
119017	3894	
119075	307	

40
24/2
50
m12/162

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80509

80509

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 21/02/2012

Required Date: 20/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS27039-08-11

Purchased

No

120

Each

41.0000

2

20

**

50

MS27039-08-11

Screw
HD

MS27039-1-15

Purchased

No

Location

Loc Qty

Loc Code

ST290

41

117441

41

20

120

Each

89.0000

2

20

**

12/3/2

12/3/2

12/3/2

MS27039-1-15

Screw
HD

Location

Loc Qty

Loc Code

ST291

89

118093

22

118574

2

119736

65

20

12/3/2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb 0.45 Kg	-21.0 in -0.53 m	-21.0 in-lb -0.24 m-Kg	+170.0 in +4.32 m	+170.0 in-lb +1.96 m-Kg
D350-588-041* Aft Door Assembly	2.0 lb 0.91 Kg	-21.0 in -0.53 m	-42.0 in-lb -0.48 m-Kg	+170.0 in +4.32 m	+340.0 in-lb +3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	-588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
2	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
1	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00